



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3403-1

Job Sheet 166751



Part No: D3403-1

Job Qty: 74 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Falcon Aviation Services (CFALC01)

PO Box 62030 Abu Dhabi, , United Arab Emirates ph:011 971 50 445 0187 fx:+971 2 444 0022.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	74 Ea		10/26/17	0.00	0.00	Start Up Machining	
100	Hardinge	74 pcs		10/27/17	0.08	9.51	Hardinge	
120	QC	74 pcs		10/27/17	0.00	0.00	QC8	
130	Packaging	74 pcs		10/27/17	0.00	0.00	Packaging3	
140	QC21-SA	74 Ea		10/27/17	0.00	0.00	QC21	

Part Op Descriptions: 100 - 1- Turn as per Folio FA556 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____

21
9-89

NOV 06 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	16	4	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	2.360inches + 0.010 - 0.000	2.370 2.360		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		
4	Bushing	0.750inches ± 0.010	0.760 0.740		
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.0Degrees ± 0.5	20.5 19.5		
8	Bushing	0.313inches ± 0.010	0.323 0.303		
9	Bushing	60.0Degrees ± 0.5	60.5 59.5		

DART
AEROSPACE
S005867

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Bushing

PART NO: D3403-1

Revision:

Operation: Start up Operation

Quantity: 74

Change No:

Mfg Date: 11/04/17

Job No: 166751

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>166751</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. <u>D3403-1</u>		Skid tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No.		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date: <u>17-11-04</u>	Step #: <u>100</u>	QTY Effective: <u>27</u>	MRB (QS1042) Approval
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Description Work Order Deviation	Disposition	
Operator had approx. 1 part out of 4 that were either under sized by .002" or over-sized by .002". Should have stopped after 1st part scrap to revise process but wasn't shure what to do with the situation. Operator training has been updated and process has been improved	→ Scrap n replace	Completed By DAS <u>17/11/04</u> 23 0-89 Lead hand / Supervisor Approval Verification <u>17-11-04</u> QC / QA Coordinator Approval  NOV 06 2017

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☒	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☒	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER: _____			